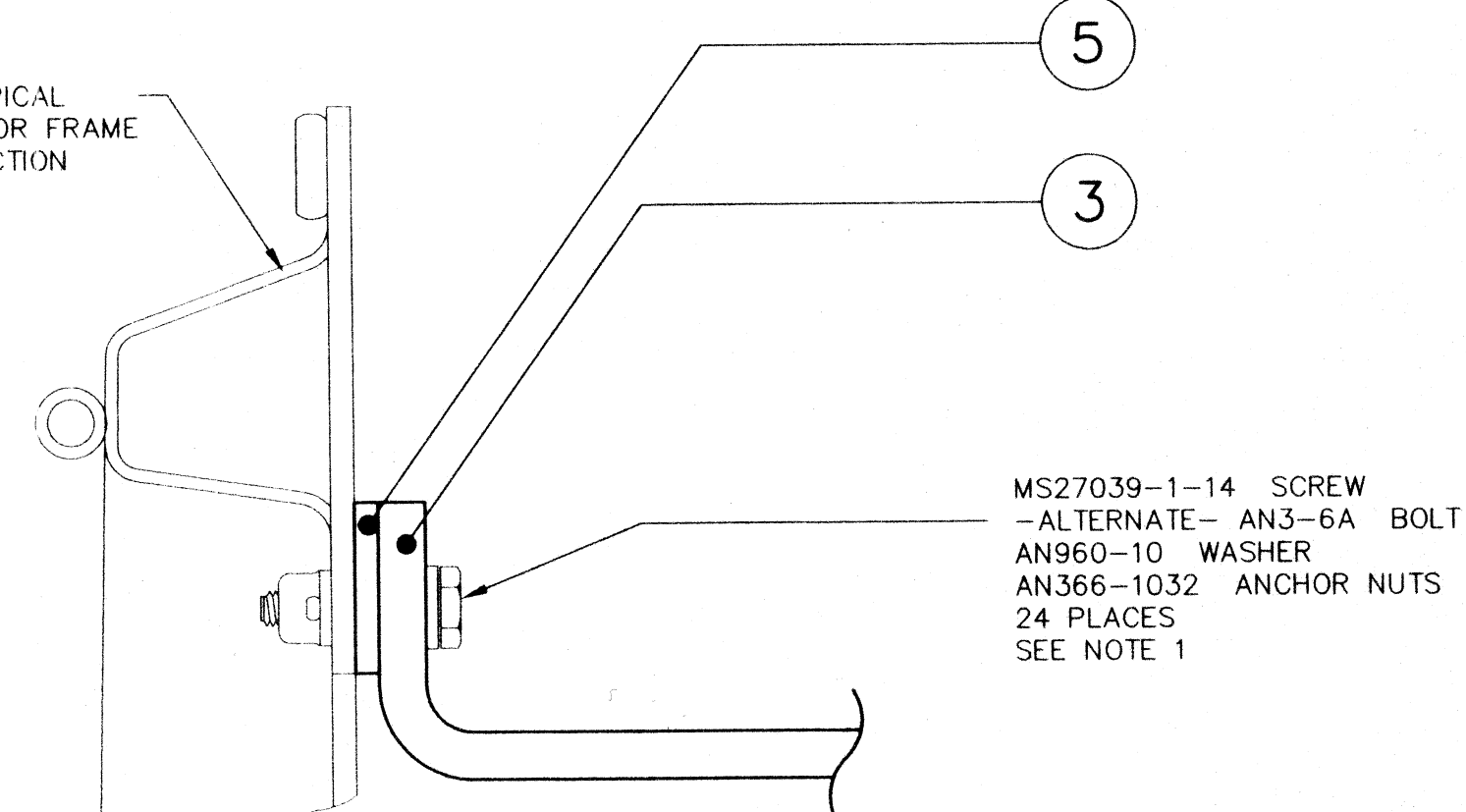


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REV.	DESCRIPTION OF CHANGE	INITIALS	DATE
4	ADDED SHEET 3 / MODIFIED DOOR INNER SKIN / CHG'D DOOR LATCH	SV	2 APR 1998
5	LARGER INST. WINDOW / LARGER RIBS / INST. PANEL CHANGED	DW	15 AUG 2000
6	ADDED ALTERNATE FASTENERS	BJC	7 JUNE 2005

CAUTION
Vertical Sighting Bubble Door fitted – Ensure top latch secured for flight.

TYPICAL DOOR FRAME SECTION



SECTION A – A

SCALE : FULL

QTY.	DASH NO.	DESCRIPTION	PART NO.
4	28	ARM GUIDE	FA20469-28
1	27	DOOR PLATE	FA20469-27
1	26	DOOR PLATE	FA20469-26
1	25	ARM	FA20469-25
1	24	ROD	FA20469-24
2	23	LINK	FA20469-23
2	22	LUG	FA20469-22
1	21	DOOR COVER PANEL	EA21469-21
	20	FLIGHT MANUAL SUPPLEMENT 214B, 214B-1	EA21469-20
	20	FLIGHT MANUAL SUPPLEMENT 212, 412	EA21269-20
	20	FLIGHT MANUAL SUPPLEMENT 205A, 205A-1	EA20569-20
1	20	FLIGHT MANUAL SUPPLEMENT 204B	EA20469-20
1	19	EAGLE SERVICE INSTRUCTION	EA20469-19
1	18	DOOR INNER SKIN	EA20469-18
1	17	ANGLE	EA20469-17
1	16	ARM REST ASSEMBLY	EA20469-16
1	15	INSTRUMENT PANEL	EA20469-15
1	14	WINDOW RETAINER	EA20469-14
1	13	INSTRUMENT WINDOW	EA20469-13
1	12	FORWARD RIB	EA20469-12
1	11	ANGLE	EA20469-11
1	10	REARWARD RIB	EA20469-10
	9	ANGLE	EA20469-09
1	8	PLACARD – INSTRUMENT PANEL	EA20469-08
1	7	ANGLE	EA20469-07
	6	ALUMINUM STRIP	EA20469-06
1	5	RUBBER STRIP	EA20469-05
1	4	DOOR LATCH ASSEMBLY	EA20469-04
1	3	PLEXIGLASS BUBBLE WINDOW	EA20469-03
	2	INSTALLATION – DOOR MOUNTED INSTRUMENTS	
	1	INSTALLATION – BUBBLE WINDOW	
2	1	DASH NO.	

NOTES

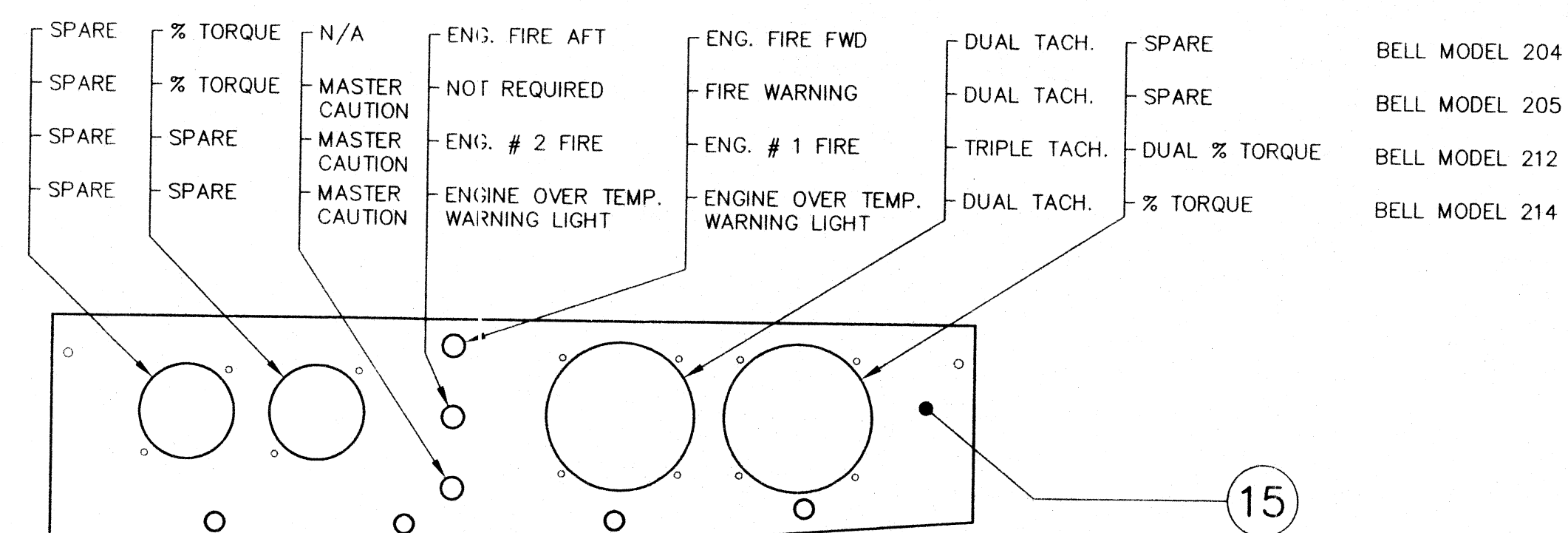
- DRILL HOLES FOR SCREWS PICKING UP EXISTING RIVET HOLES AT APPROXIMATELY THE DISTANCES SHOWN.
- INSTALL ALL RIVETS IN ACCORDANCE WITH AC43.13-1B, PAR 4-58, AND FIG. 4-6 USING THE FOLLOWING LEGEND:
 - - - EXISTING RIVET (REF)
 + MS20470AD3
 * MS20470AD4
 ⊕ MS20426AD3
 ⊙ MS20426AD4
- PICK UP EXISTING RIVET HOLES IN DOOR THROUGHOUT ENTIRE PANEL.
- PLACARD INSTRUMENT PANEL WITH ITEM 8 AS SHOWN.

1 INSTALLATION – BUBBLE WINDOW

SCALE 1 : 3

BASIC CODE		DASH NO. FOR DIA N=MFD HEAD NEAR SIDE F=MFD HEAD FAR SIDE		APPROVALS		DATE		AERO DESIGN LTD. CONSULTING ENGINEERS, TRANSPORT CANADA APPROVALS, DAR 290M 1045 McTAVISH ROAD N.E., CALGARY, AB. T2E 7G9							
D=DIMPLE DIGIT = # OF SHEETS TO BE DIMPLED C=COUNTERSUNK		DASH NO. FOR LENGTH		DRAWN: E. BURGAIN		26 AUG 91		EAGLE COPTERS LTD. 823 McTAVISH ROAD N.E., CALGARY, ALBERTA, T2E 7G9 BELL 204, 205, 212 & 214 VERTICAL REFERENCE DOOR INSTALLATION							
				CHECKED:											
				STRESS:											
BASIC CODES:		✱ ∩ INSTALL NEW RIVET		UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ON: DECIMALS ANGLES X.XXX ±0.010 ±1/2° X.XX ±0.03 X.X ±0.1				SCALE AS NOTED		DWG. SIZE A1		DWG. NO. D2046901		REV. 6	
BJ = MS20470AD BB = MS20426AD LZ = NAS1097AD CX = MS20470DD		✱ ∩ REMOVE/REPLACE RIVET													
		÷ ∩ EXISTING RIVET						SHEET 1 OF 3							

REV.	DESCRIPTION OF CHANGE	INITIALS	DATE
4	ADDED SHEET 3 / MODIFIED DOOR INNER SKIN / CHG'D DOOR LATCH	SV	2 APR 1998
5	LARGER INST. WINDOW / LARGER RIBS / INST. PANEL CHANGED	DW	15 AUG 2000
6	ADDED ALTERNATE FASTENERS	BUC	7 JUNE 2005



SECTION B - B

17

15

07

13

14

11

EXISTING RIB
SEE NOTE 5

FOR WIRING SCHEMATIC
SEE DWG. D2046903 &

SECTION C - C

12

14

10

11

CONTINUE RIVETS BENEATH ITEM 14
USING MS20426AD3 RIVETS

SEE NOTE 8

MS27039-0807 SCREW
NAS696A08 ANCHOR NUT
-ALTERNATE-
MS27039-1-07 SCREW
NAS696A3 ANCHOR NUT
-ALTERNATE-
AN3-3A BOLT
NAS696A3 ANCHOR NUT
20 PLACES
SEE NOTE 6

SEE NOTE 7

NOTES

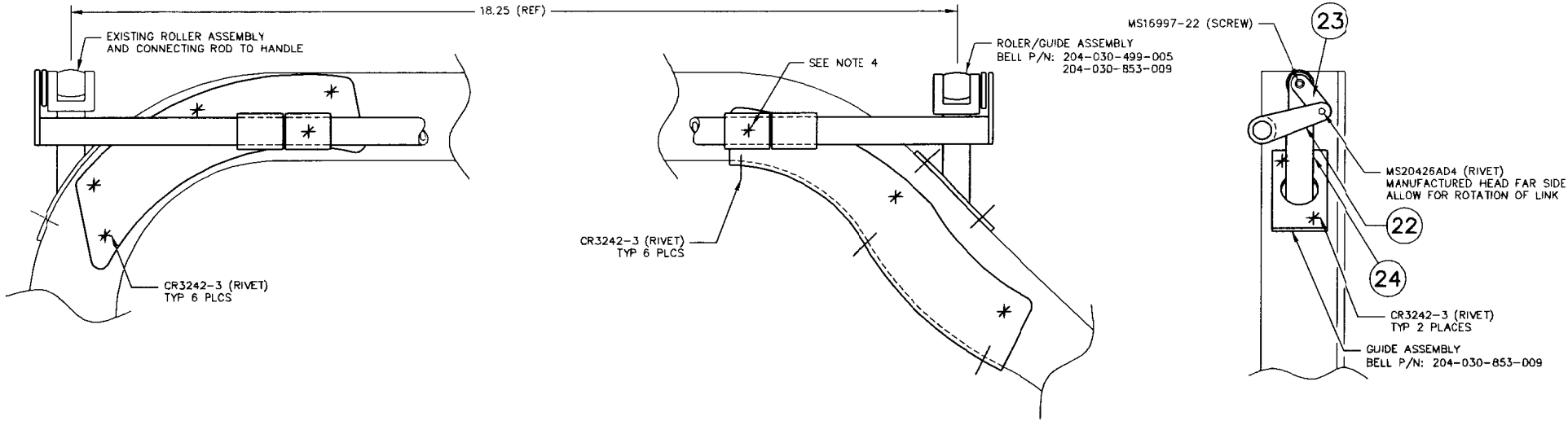
2. INSTALL ALL RIVETS IN ACCORDANCE WITH AC43.13-1B, PAR 4-58, AND FIG. 4-6 USING THE FOLLOWING LEGEND:
-|- EXISTING RIVET (REF)
+ MS20470AD3
* MS20470AD4
⊕ MS20426AD3
⊗ MS20426AD4
3. PICK UP EXISTING RIVET HOLES IN DOOR THROUGHOUT ENTIRE PANEL.
5. CUT DOWN EXISTING RIB AS SHOWN
6. DRILL HOLES IN DOOR AND INSTALL ANCHOR NUTS ON ASSEMBLY TO MATCH HOLES IN PARTS 13 & 14.
7. INSTRUMENTS FITTED INTO DOOR ARE EITHER REMOVED FROM LEFT HAND INSTRUMENT PANEL OR ARE PROVIDED AS EXTRA INSTRUMENTS. WIRING ROUTED THOUGH DOOR AND BEHIND LEFT SIDE INSTRUMENT PANEL AND PLUGGED INTO LEFT SIDE INSTRUMENT HARNESS. INSTRUMENT WIRING IN DOOR BUNDLED AND BOUND WITH CORD TO PROVIDE PIGTAIL WITH LENGTH TO ALLOW FULL OPENING OF DOOR.

[illegible]

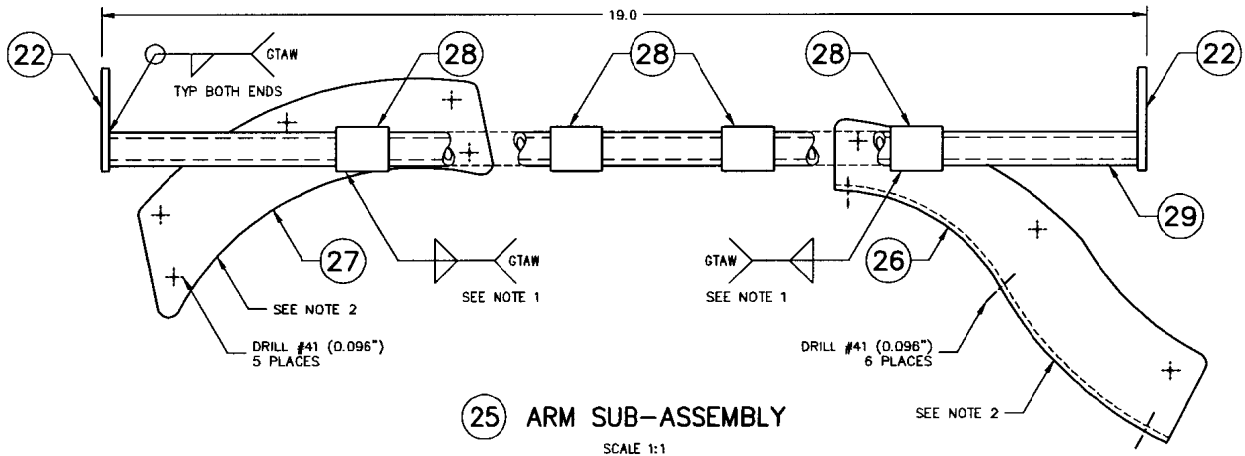
WEIGHT AND BALANCE						
ITEM	DESCRIPTION	WEIGHT (LBS.)	LONGITUDINAL		LATERAL	
			ARM (INS.)	MOMENT (LB.-IN.)	ARM (INS.)	MOMENT (LB.-IN.)
1 & 2	NET CHANGE WHEN VERTICAL SIGHTING DOOR REPLACES STANDARD DOOR.	2.0	+50.8	+101.6	-40.0	-80.0
	INSTRUMENT POSITION CHANGE (NET)			+45.0		-186.0
	NET CHANGE	2.0	73.3	+146.6	-133.0	-266.0

BASIC CODE			DASH NO. FOR DIA N=MFD HEAD NEAR SIDE F=MFD HEAD FAR SIDE		APPROVALS		DATE		AERO DESIGN LTD. CONSULTING ENGINEERS, TRANSPORT CANADA APPROVALS, DR 290M 1045 MCTAVISH ROAD N.E., CALGARY, AB, T2E 7G9							
D=DIMPLE DIGIT = # OF SHEETS TO BE DIMPLED C=COUNTERSUNK			DASH NO. FOR LENGTH		DRAWN: E. BURGOIN		28 SEPT 91		EAGLE COPTERS LTD. 823 MCTAVISH ROAD N.E., CALGARY, ALBERTA, T2E 7G9 BELL 204, 205, 212 & 214 VERTICAL REFERENCE DOOR INSTALLATION							
					CHECKED:											
					STRESS:											
BASIC CODES: BJ = MS20470AD BB = MS20426AD LZ = NAST1097AD CX = MS20470DD			* C INSTALL NEW RIVET + U REMOVE/REPLACE RIVET - X EXISTING RIVET		UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ON: DECIMALS ANGLES X.XXX ±0.010 ±1/2° X.XX ±0.03 X.X ±0.1				SCALE 1 : 3		DWG. SIZE DWG. NO.		REV.			
									SHEET 2 OF 3		A1		D2046901		6	

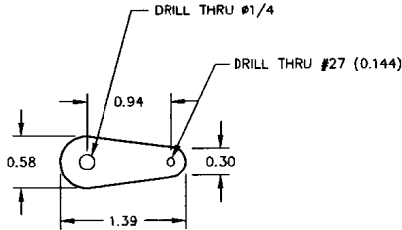
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REV.	DESCRIPTION OF CHANGE	INITIALS	DATE
1	INNER PAIR OF ARM GUIDES CHANGED FROM WELDED TO RIVETED	DW	15 AUG 2000



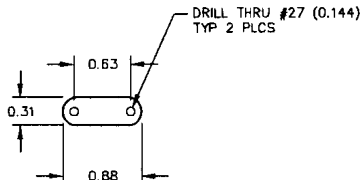
UPPER DOOR LATCH ASSEMBLY
SCALE 1:1



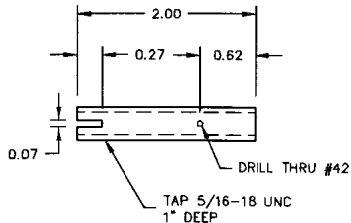
25 ARM SUB-ASSEMBLY
SCALE 1:1



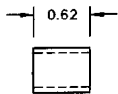
22 LUG
SCALE 1:1



23 LINK
SCALE 1:1



24 ROD
SCALE 1:1



28 ARM GUIDE
SCALE 1:1

- NOTES FOR SHEET 3.
- WELDING OF 4130 STEEL ALLOY TO BE COMPLETED BY GTAW METHOD TO AMS2685C. WELDING ROD SHALL CONFORM TO AMS 8457A OR LATER REVISION.
 - HEAT AND FORM DOOR PLATES (ITEM 26 & ITEM 27) TO SHAPE OF DOOR JAM. PILOT HOLE LOCATIONS ARE APPROXIMATE. MAINTAIN 2D EDGE DISTANCE.
 - THOROUGHLY DEGREASE, PRIME, AND PAINT ALL PIECES AFTER ASSEMBLY.
 - OUTER PAIR OF ARM GUIDES (ITEM 28) WELDED TO DOOR PLATES AS SHOWN. INNER PAIR OF ARM GUIDES LEFT LOOSE UNTIL ASSEMBLY WITH DOOR AND THEN FASTENED TO ARM WITH CR3242-3 RIVETS AFTER ARM ALIGNMENT.

1	29	ARM	EA20469-29	4130 STEEL	MIL-T-6736	#3/8 O.D. x 0.093 WALL
4	28	ARM GUIDE	EA20469-28	4130 STEEL	MIL-T-6736	#1/2 O.D. x 0.063 WALL
1	27	DOOR PLATE	EA20469-27	MILD STEEL		0.063" SHEET
1	26	DOOR PLATE	EA20469-26	MILD STEEL		0.063" SHEET
1	25	ARM SUB-ASSEMBLY	EA20469-25			
1	24	ROD	EA20469-24	4130 STEEL	MIL-T-6736	#3/8 O.D. x 0.093 WALL
2	23	LINK	EA20469-23	4130 STEEL	MIL-S-18729	0.063" SHEET
2	22	LUG	EA20469-22	4130 STEEL	MIL-S-18729	0.063" SHEET
1	21	DOOR COVER PANEL	EA21469-21			
	20	FLIGHT MANUAL SUPPLEMENT 214B, 214B-1	EA21469-20			
	20	FLIGHT MANUAL SUPPLEMENT 212, 412	EA21269-20			
	20	FLIGHT MANUAL SUPPLEMENT 205A, 205A-1	EA20569-20			
1	20	FLIGHT MANUAL SUPPLEMENT 204B	EA20469-20			
1	19	EAGLE SERVICE INSTRUCTION	EA20469-19			
1	18	DOOR INNER SKIN	EA20469-18			
1	17	ANGLE	EA20469-17			
1	16	ARM REST ASSEMBLY	EA20469-16			
1	15	INSTRUMENT PANEL	EA20469-15			
1	14	WINDOW RETAINER	EA20469-14			
1	13	INSTRUMENT WINDOW	EA20469-13			
1	12	FORWARD RIB	EA20469-12			
1	11	ANGLE	EA20469-11			
1	10	REARWARD RIB	EA20469-10			
1	9	ANGLE	EA20469-09			
1	8	PLACARD - INSTRUMENT PANEL	EA20469-08			
1	7	ANGLE	EA20469-07			
1	6	ALUMINUM STRIP	EA20469-06			
1	5	RUBBER STRIP	EA20469-05			
1	4	DOOR LATCH ASSEMBLY	EA20469-04			
1	3	PLEXIGLASS BUBBLE WINDOW	EA20469-03			
	2	INSTALLATION - DOOR MOUNTED INSTRUMENTS				
	1	INSTALLATION - BUBBLE WINDOW				
QTY.	DASH NO.	DESCRIPTION	PART NO.	MATERIAL	MATERIAL SPEC.	STOCK SIZE

BASIC CODE		APPROVALS		DATE		AERO DESIGN LTD.	
D=DIMPLE DIGIT = # OF SHEETS TO BE DIMPLED C=COUNTERSUNK		DASH NO. FOR DIA N=MFD HEAD NEAR SIDE F=MFD HEAD FAR SIDE		DRAWN E. BURGON		CONSULTING ENGINEERS, TRANSPORT CANADA APPROVALS, DASH 8900 1045 McTAVISH ROAD N.E., CALGARY, AL. T2E 7G9	
BASIC CODES: BJ = MS20470AD BB = MS20426AD LZ = NAS1097AD CX = MS204700D		DASH NO. FOR LENGTH		CHECKED:		EAGLE COPTERS LTD.	
				STRESS:		823 McTAVISH ROAD N.E., CALGARY, ALBERTA, T2E 7G9	
				UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ON:		BELL 204, 205, 212 & 214 VERTICAL REFERENCE DOOR INSTALLATION	
				DECIMALS X.XXX ±0.010 X.XX ±0.03 X.X ±0.1		SCALE AS NOTED	
				ANGLES ±1/2"		DWG. SIZE	
						D2046901	
						REV.	
						1	